

Date: Tuesday, 4/25/2006 7:36:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : "T" HANDLE ASSEMBLY
 Job Number : 26811A-2
 Estimate Number : 11179
 P.O. Number : N/A
 This Issue : 4/25/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 25559
 Written By : SRA
 Checked & Approved By : JLM
 Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM

Part Number : D2282041
 Drawing Number : D2282 REV E
 Project Number : N/A
 Drawing Revision : E
 Material : N/A
 Due Date : 5/20/2006 Qty: 100 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D22823 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2282-3 Handle tube B26815
B23036B

CPL 06.06.12 (70)

CPL 06.06.06 (30)

2.0 D22825 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2282-5 Handle tube B26816

CPL 06.06.12 (70) (30)

CPL 06.06.08

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS

Filling Rod

M100527

Dwg Rev: E

CPL 06.06.12 (70)

CPL 06.06.08

4.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

NA 06/06/12 (70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: • Tuesday, 4/25/2006 7:36:48 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: *T* HANDLE ASSEMBLY

Job Number: 26811A

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

240 06:06:13

70

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/13 70

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/06/13 70

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/06/14 70

Job Completion



u 06-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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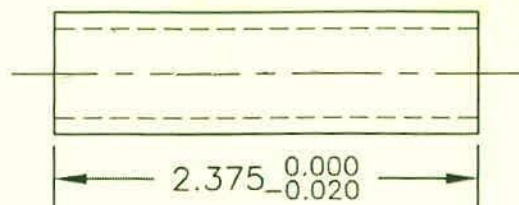
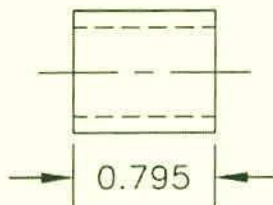
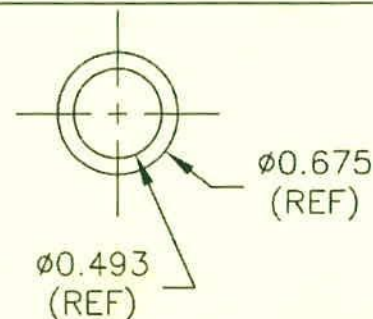
NOTE: Date & initial all entries

DART

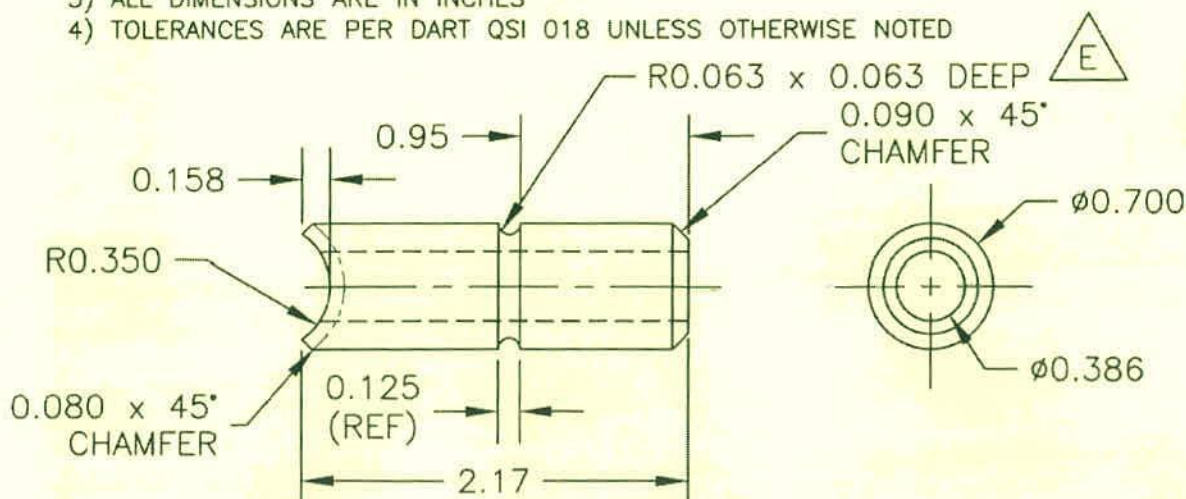
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

BS/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

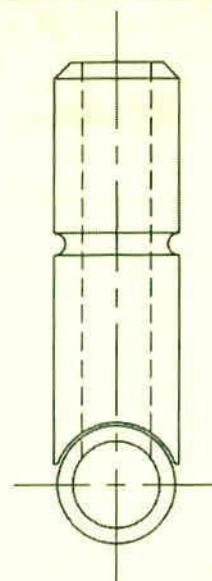
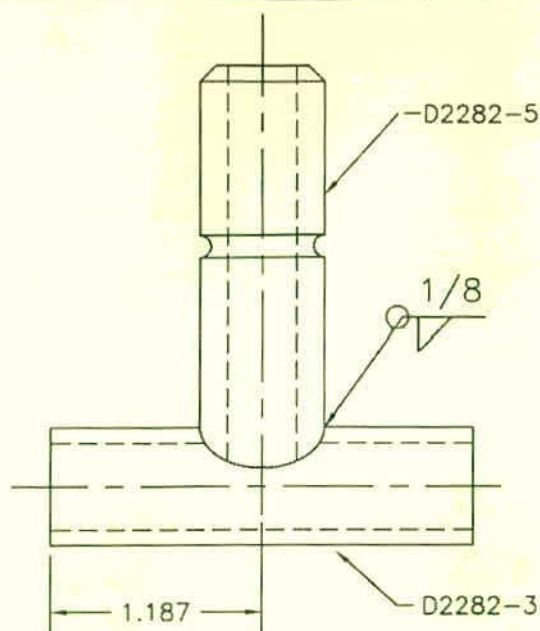
NO. 26811A

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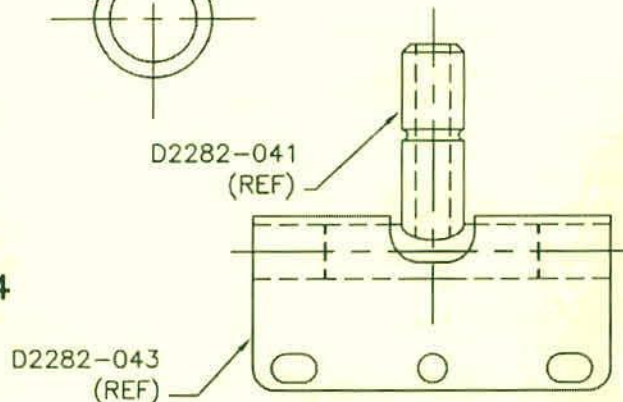


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CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

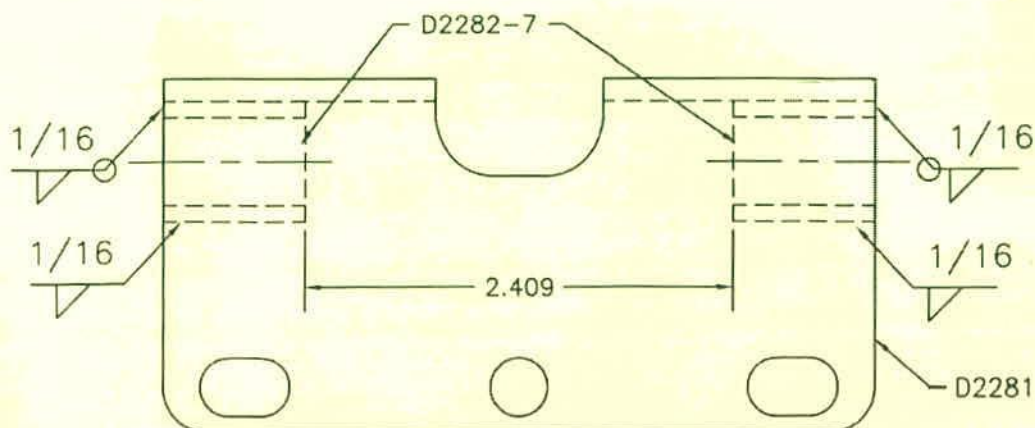


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[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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